

Date: Friday, 05/01/2007 11:16:10 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 30051	
Estimate Number : 11243	
P.O. Number : N/A	Part Number : D33795
This Issue : 05/01/2007 S.O. No. : N/A	Drawing Number : D3379 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : 91A
Previous Run : 30051	Material : 12/01/2007
Written By : <u>W</u>	Due Date : 12/01/2007 Qty: 8 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 05-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B0625X0200	1010-1025 steel bar .625 x 2.00
-----	-----------------	---------------------------------



Comment: Qty.: 0.2258 f(s)/Unit Total : 1.8060 f(s)
1010-1025 steel bar .625 x 2.00
batch: ml 103210 ml 07 06 17 (8)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3379
Dwg Rev: C
Prog Rev: C
2-Deburr if necessary

ml 07 06 17 (8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 06 17 (8)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

J.F. 07/06/28 (8)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/06/28

Date: Friday, 05/01/2007 11:16:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30051

Part Number: D33795

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SC 07-06-08

(8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

JD + SM

PTD

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 96

07/01/08

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/09

Job Completion



07/06/09

Date: Wednesday, 12/20/2006 1:46:45 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 30051	
Estimate Number : 11243	
P.O. Number :	Part Number : D33795
This Issue : 12/20/2006 S.O. No. :	Drawing Number : D3379 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 25150	Material :
Written By : <u> </u>	Due Date : 1/6/2007 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A New Issue 05-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** Issue P/O: _____

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg D3379

Possible supplier: Ind. Laser

Material release note is required.

Waterjet

2.0	D33795F	PLATE-FLAT
-----	---------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Plate R22/R44

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

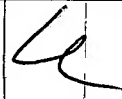
**Comment:** DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-07-78	7/8	permanent change					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:46:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30051

Part Number: D33795

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

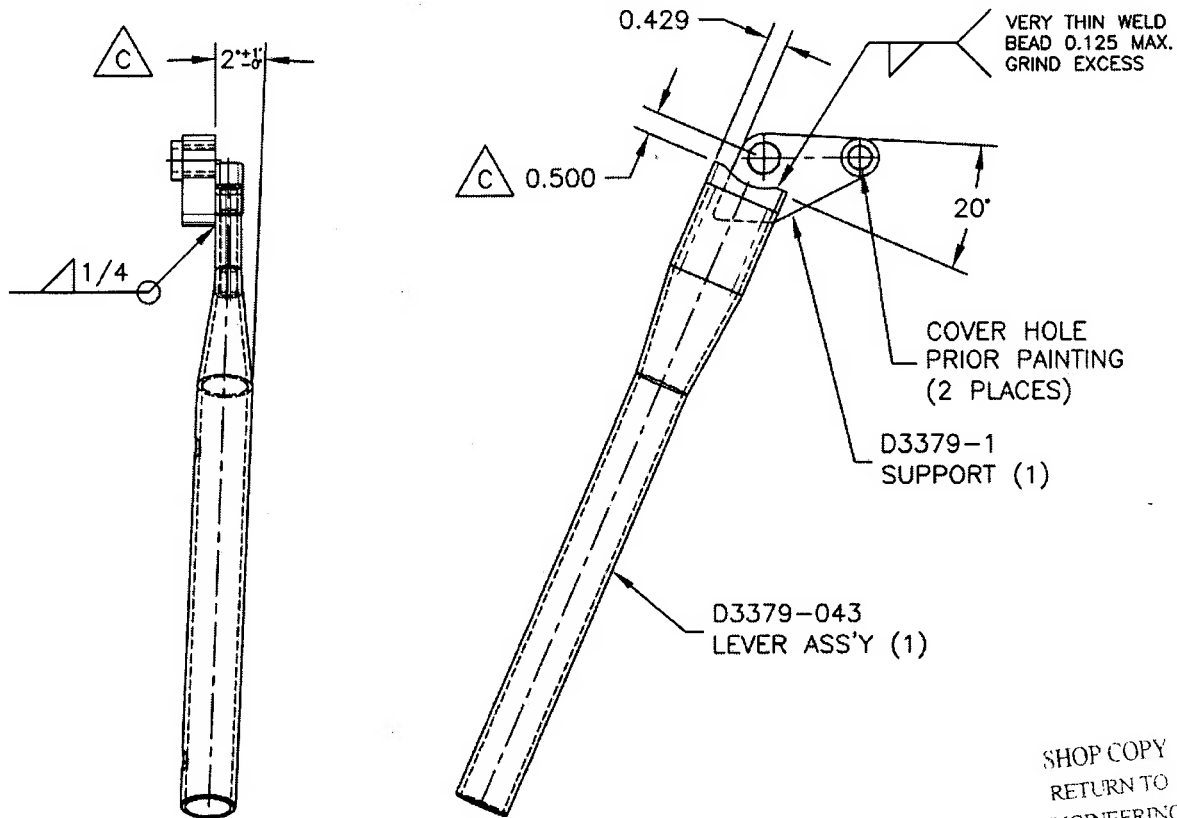
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3379	REV. C SHEET 1 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.02.25	RE-DESIGN D3379-5	
C	05.05.27	2' WAS 4'; UPDATE DIMENSIONS	

RELEASED
as/ot/ok



D3379-041 ARM WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 30051

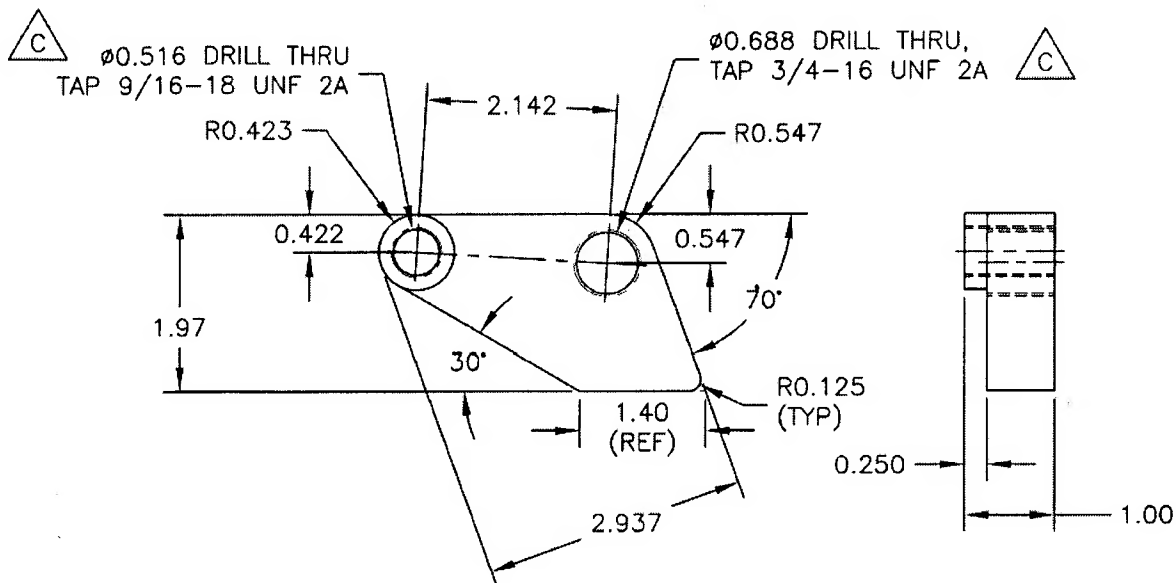
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 2 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:2

RELEASED
[Signature]
05/07/05



D3379-1 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.000 STEEL (REF. DART SPEC. M1010-B1.000x02.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 30051

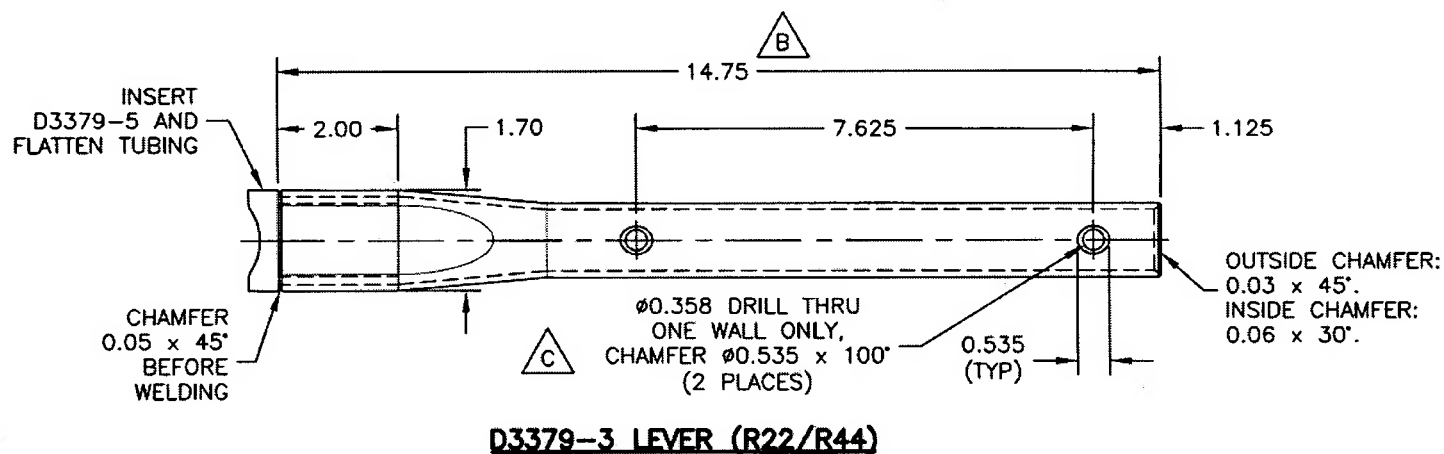
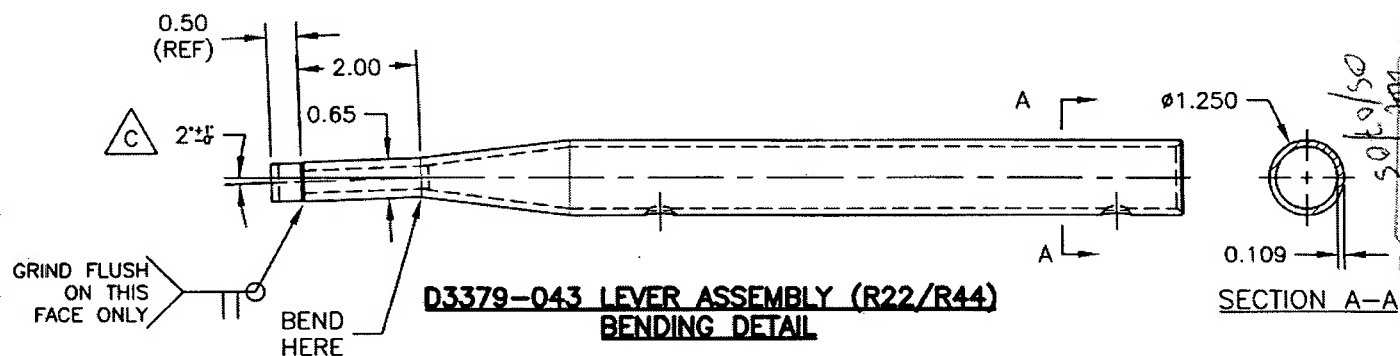
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	DRAWING NO.
05.05.27	ARM WELDMENT	D3379
		SHEET 3 OF 4
		SCALE
		1:3

RELEASED



NOTES:

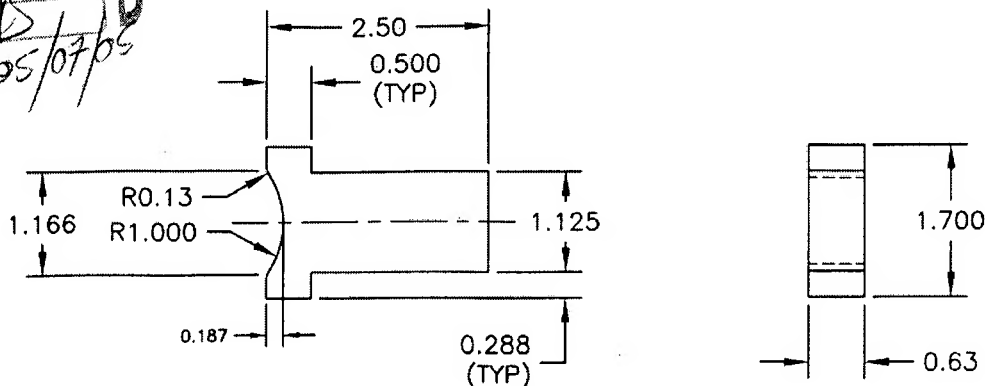
- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.250W.109)
- 2) WELD PER QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
NO. 20051

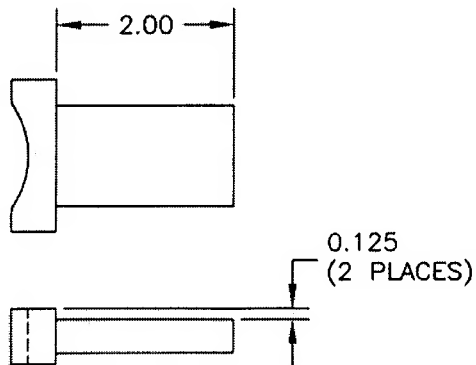
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 4 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1

RELEASED
[Signature]
05/07/05



D3379-5 LASER CUT PATTERN (R22/R44)



D3379-5 PLATE (R22/R44)

NOTES:

- 1) MATERIAL: 1010-1025 BAR MILD STEEL, 0.625 THICK
(REF. DART SPEC. M1010-B0.625)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 30051

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DART AEROSPACE LTD		Work Order: 30051
Description: Plate		Part Number: D3319-5
Inspection Dwg: D3319	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.700	+/-0.010	1.700	✓		VEN	
B 0.63	+/-0.030	0.627	✓		VEN	
C 1.166	+/-0.010	1.166	✓		VEN	
D 0.288	+/-0.010	0.290	✓		VEN	
E 1.125	+/-0.010	1.124	✓		VEN	
F 0.500	+/-0.010	0.500	✓		VEN	
G 2.50	+/-0.030	2.50	✓		VEN	
H 2.00"	±.030"	2.010"	✓			
I .125"	±.010"	.128"	✓			
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: MM/EF	Audited by: BG	Prototype Approval:	N/A
Date: 07.06.28	Date: 07.06.28	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	